

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023299**Date Inspected:** 22-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

Bay 14 / OBG segment 14W

This QA inspector performed Ultrasonic Testing (UT) approximately 10% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated UT report for this date. The member is identified as OBG 14W welds as per ZPMC notification # 08903.

The weld designations reviewed are as follows:

SEG3020V-073, 048

SEG3020U-587

SEG3020BB-109

Bay 14 / OBG segment 14E

This QA inspector performed Ultrasonic Testing (UT) approximately 10% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated UT report for this date. The member is identified as OBG 14E welds as per ZPMC notification # 08903.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

The weld designations reviewed are as follows:

SEG3019M-228, 229, 232, 233, 236, 237, 240, 241
SEG3019E-2-155, 159

Bay 14 / OBG segment 14E

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 2G position of weld # SEG3019W-081. The welder is identified as 067877.

Quality Control (QC) is identified as Lv Li Qing. The welding variables recorded by QC appeared to comply with WPS- B-T-2232-ESAB. See attached photograph Pic_001.

Bay 14 / OBG segment 14E

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of repair weld # SEG3019BB-133, as per B-WR # 20589. The welder is identified as 058087. Quality Control (QC) is identified as Lv Li QIng. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G(4F)-FCM-Repair.

Bay 14 / OBG segment 14E

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of weld # SEG3019*-001. The welder is identified as 066733. Quality Control (QC) is identified as Lv Li QIng. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1.

Bay 14 / OBG segment 14E

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 2G position of weld # SEG3019*-032. The welder is identified as 044772. Quality Control (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-TC-U4b-FCM-1.

Bay 14 / OBG segment 14E

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 2G position of weld # SEG3019*-013. The welder is identified as 058102. Quality Control (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-TC-U4b-FCM-1.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No relevant conversations reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey (+86) 15000026784 , who represents the Office of Structural Materials for your project.

Inspected By:	Gade,Ramesh	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
